

Date: Wednesday, 7/11/2007 3:05:53 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                  |                |
|-----------------------|--|------------------|----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : STEP LEG     |
| Job Number            | : 33510C   |                  |                |
| Estimate Number       | : 10382  |                  |                |
| P.O. Number           | : <i>N/A</i>   | Part Number      | : D30655       |
| This Issue            | : 7/11/2007  | S.O. No.         | : <i>N/A</i>   |
| Prsht Rev.            | : NC   | Drawing Number   | : D3065 REV. B |
| First Issue           | : <i>N/A</i>   | Project Number   | : N/A          |
| Previous Run          | : 32032C   | Drawing Revision | : B            |
|                       |  | Material         | : <i>N/A</i>   |
| Written By            | : <i>[Signature]</i>   | Due Date         | : 7/30/2007    |
| Checked & Approved By | : <i>[Signature]</i>   | Qty:             | 500 Um: Each   |
| Comment               | Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF<br>Est Rev:D Now on Water Jet 06-04-11 JLM<br>Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM |                  |                |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

ISSUE P.O TO GFI *4/4/9* *C 207/07/12*  
 CUT AND FORM PER DRWG D3065 REV.B

*(500)*

|     |        |          |
|-----|--------|----------|
| 2.0 | D30655 | Step Leg |
|-----|--------|----------|



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 RECEIVE AND INSPECT FOR TRANSIT DAMAGE  
 ENSURE MATERIAL CERTIFICATION IS ATTACHED

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

*# 07-08-12*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 9/10/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 33510C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er 06/04/12 X500 counted*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FR / BR 07/09/13 counted 500*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*Er 07/09/13 X500*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CA*

*SB 07/09/24 500*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/09/24*

Job Completion



*U 07-09-24*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

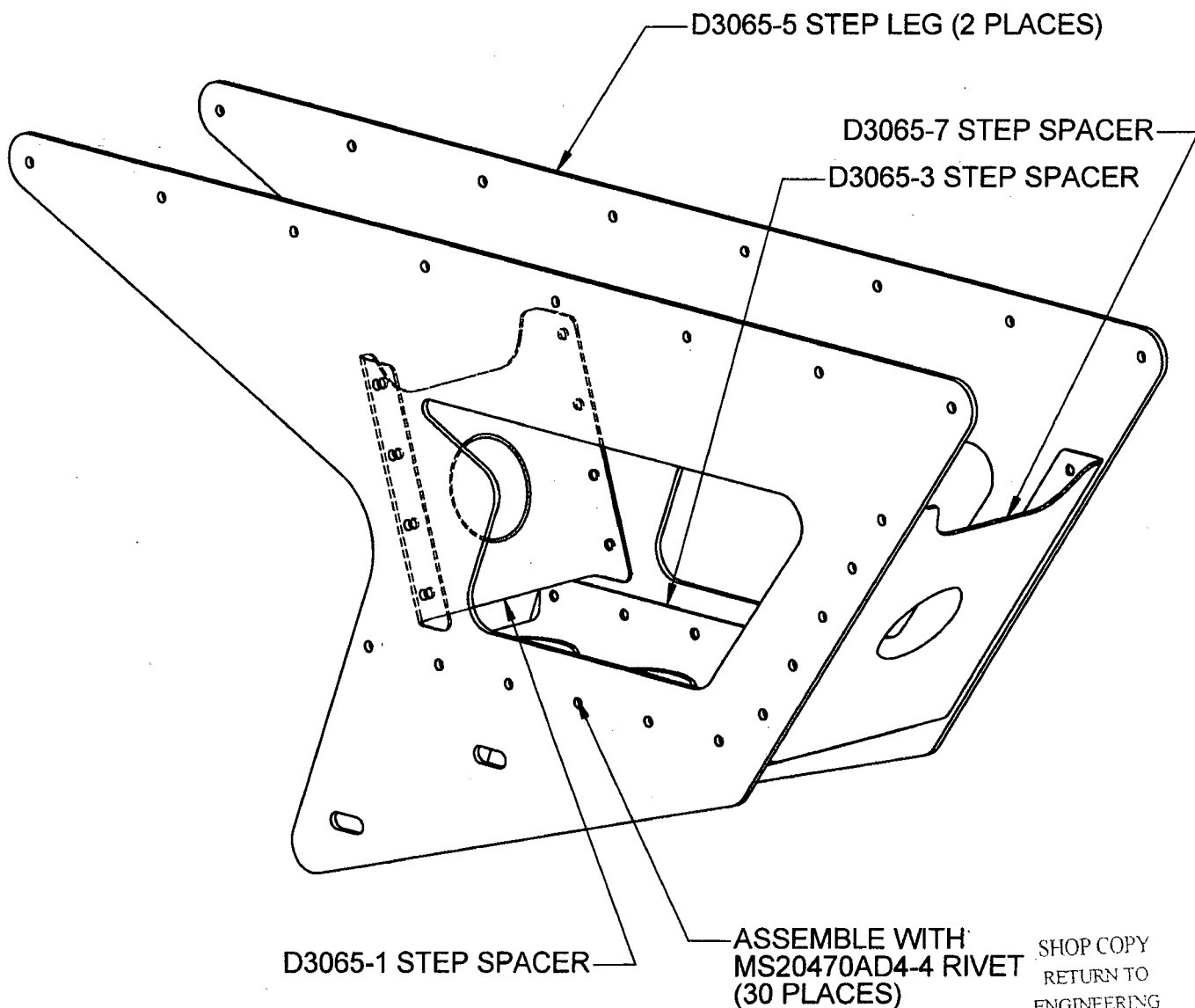




|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 1 OF 5 |
| DATE<br>06.05.23     |                                | TITLE<br>STEP LEG ASSEMBLY                        | SCALE<br>1:2           |
| A                    | 02.09.11                       | NEW ISSUE   |                        |
| B                    | 06.05.23                       | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5        |                        |

RELEASED

06.06.20 *[Signature]*

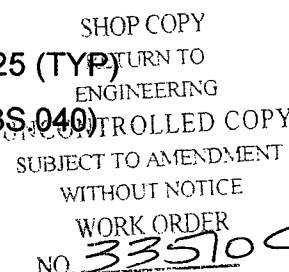
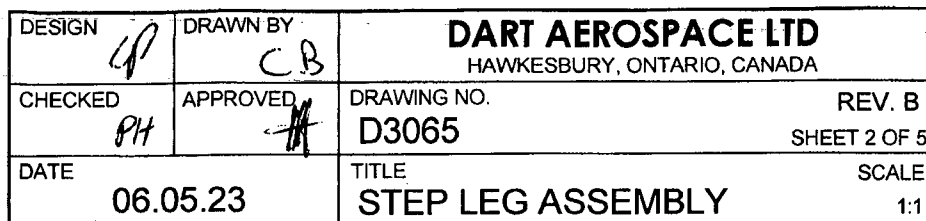


## D3065-041 STEP LEG ASSEMBLY

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WITHOUT NOTICE  
WORK ORDER  
NO. 33510 c

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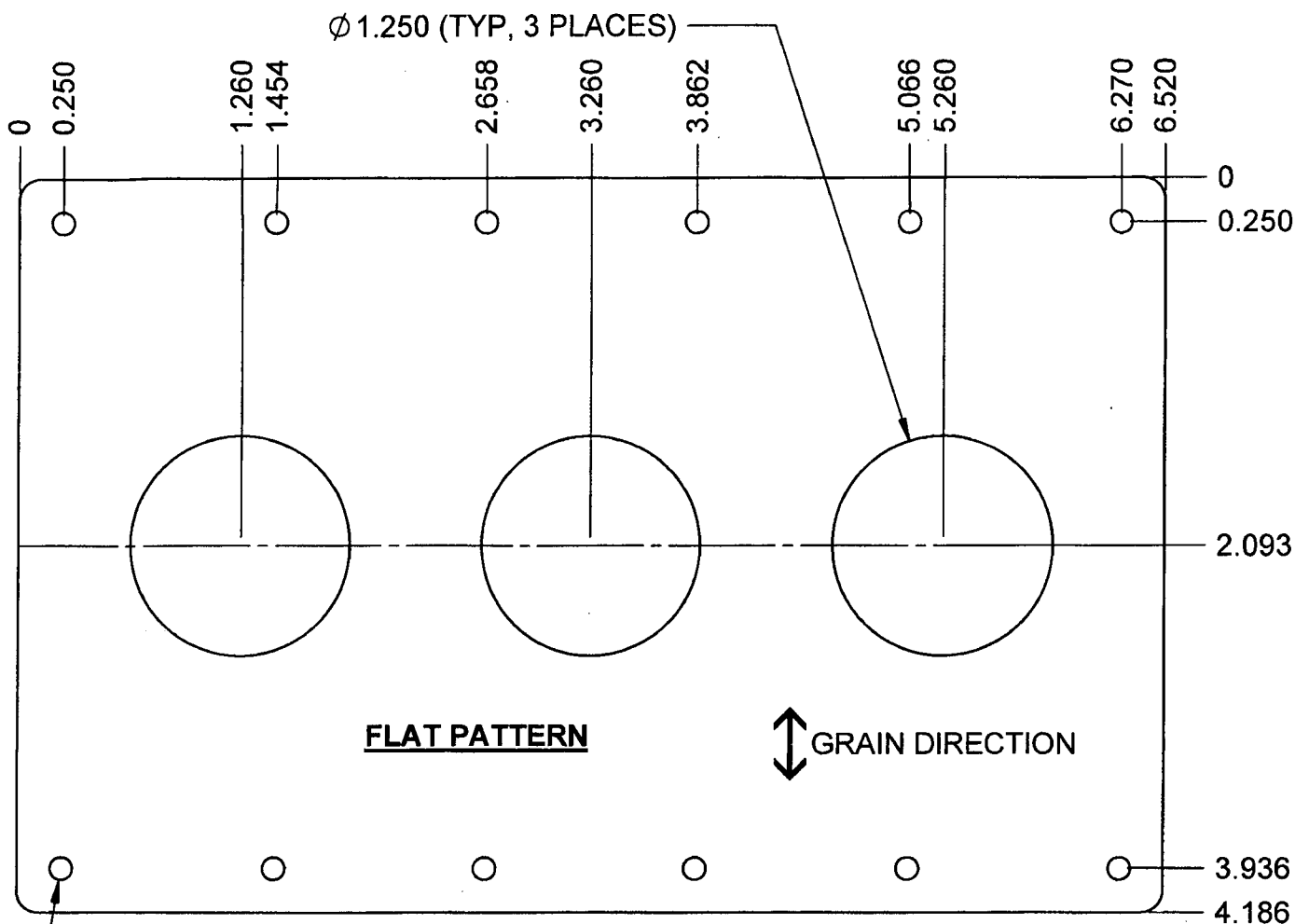
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|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
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| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 3 OF 5 |
| DATE<br>06.05.23     |                                | TITLE<br>STEP LEG ASSEMBLY                        | SCALE<br>1:1           |

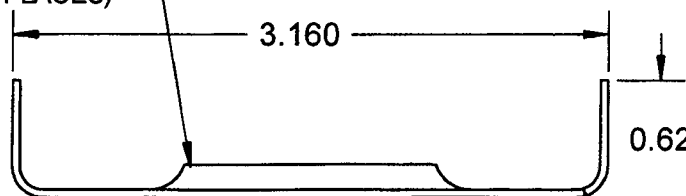


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

*06.06.20*



**BEND DETAIL**

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### D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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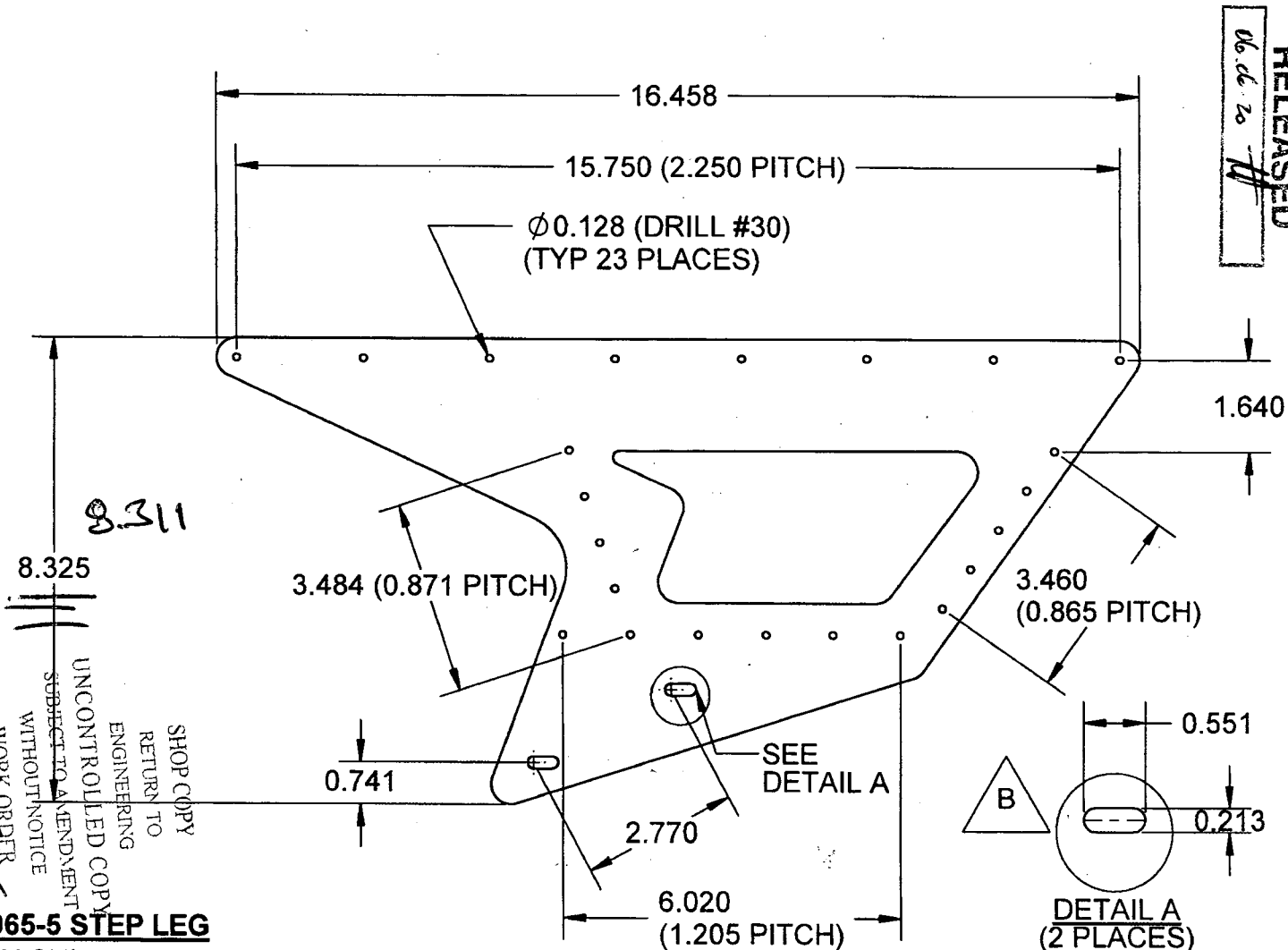
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**DART**

|                  |                            |                      |  |
|------------------|----------------------------|----------------------|--|
| DESIGN           | APPROVED                   | DRAWN BY             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>PH    | APPROVED<br>C.B.           | DRAWING NO.<br>D3065 | REV. B   |
| DATE<br>06.05.23 | TITLE<br>STEP LEG ASSEMBLY | SHEET 4 OF 5         | SCALE<br>1:3   |

RELEASED  
06.06.20

**D3065-5 STEP LEG**

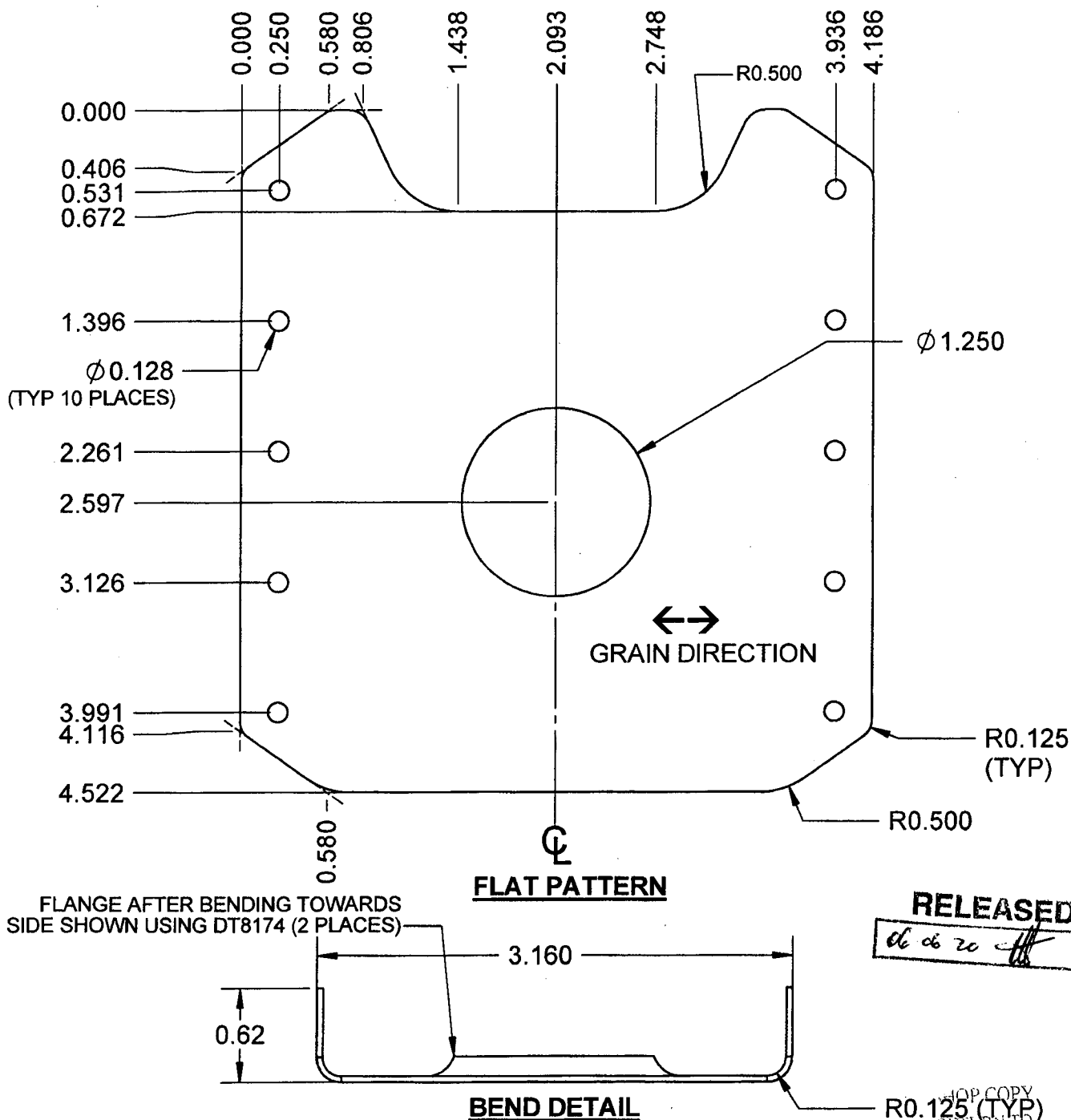
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3065</b>                              | REV. B<br>SHEET 5 OF 5 |
| DATE<br><b>06.05.23</b> |                                | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:1           |



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

ENDU À / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7



# BON DE LIVRAISON - SHIPPING MEMO

| DATE DE LIVRAISON<br>SHIPPING DATE | N° BON DE LIVRAISON<br>SHIPPING MEMO NO. |
|------------------------------------|--|
| 2007/08/16                         | 0371692                                  |

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

| CODE DE CLIENT<br>CUSTOMER CODE | N° DE CONTRAT<br>JOB NO.           | N° COMMANDE<br>PO NO.    | VIA<br>SHIP VIA |
|---------------------------------|------------------------------------|--------------------------|-----------------|
| DART GFI-0299                   | J0165073                           | PO00004149               |                 |
| QUANTITÉ<br>QUANTITY            | VOTRE N° DE PIÈCE<br>YOUR PART NO. | DESCRIPTION              |                 |
| 500                             | D30655                             | STEP LEG<br>C OF C REQ'D |                 |

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE RÉCEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

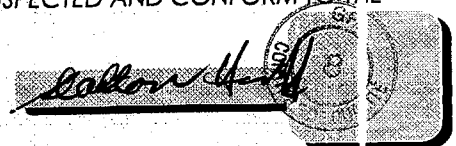
|                          |          |                    |             |               |          |     |      |
|--------------------------|----------|--------------------|-------------|---------------|----------|-----|------|
| CERTIFICATE NO.          | 1        | OUR JOB NO         | J0165073    | SHIPPING MEMO | 0371692  |     |      |
| ITEM                     | QUANTITY | PURCHASE ORDER     | PART NUMBER | REV           | NAME     | DWG | ISSE |
| -                        | 500 PCS  | PO00004149         | D30655      | B             | STEP LEG | B   |      |
| MATERIAL                 |          | SUPPLIED BY        |             | MAT. REL. NO. |          |     |      |
| AL 6061-T6 (QQ-A-250/11) |          | SAMUEL / ALCOA INC |             | H/N # 655133  |          |     |      |

|   | PROCESS                                 | PROCESSOR | RELEASE NOTE # |
|---|---|-----------|----------------|
| 1 | FIRST ARTICLE INSPECTION REPORT ON FILE | GFI       | CONFORMS       |
| 2 |   |           |                |
| 3 |   |           |                |
| 4 |   |           |                |
| 5 |   |           |                |
| 6 |   |           |                |
| 7 |   |           |                |
| 8 |   |           |                |
| 9 |   |           |                |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 16 AUGUST 2007

G.F.I. Q.C. REP.



# **LES MÉTAUX SPÉCIALISÉS SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

## **LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE**

**Date:** 17 JUILLET 2007

**Company Name:** G.F.I. Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe Claire, Qué.  
**Zip Code:** H9R 1A1

**# du client:** 71992  
**Customer's order #:**

**# de commande SSMQ:** 870053  
**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

| Notre/Our<br>Item # | # de<br>pièces/<br># of pieces | Épaisseur/Grandeur<br>Guage/Size | Alliage/Trempe<br>Alloy/Temper | Spécification /<br>Specification | Lot/Heat          |
|---------------------|--------------------------------|----------------------------------|--------------------------------|----------------------------------|-------------------|
| <del>2</del>        | <del>4</del>                   | <del>.080" X 48" X 144"</del>    | <del>6061 T6</del>             | <del>AMS-QQ-A-250/11</del>       | <del>555791</del> |
| 2                   | 10                             | .080" X 48" X 144"               | 6061 T6                        | AMS-QQ-A-250/11                  | 655133            |
| <del>2</del>        | <del>6</del>                   | <del>.080" X 48" X 144"</del>    | <del>6061 T6</del>             | <del>AMS-QQ-A-250/11</del>       | <del>668468</del> |
|                     |                                |                                  |                                |                                  |                   |
|                     |                                |                                  |                                |                                  |                   |
|                     |                                |                                  |                                |                                  |                   |
|                     |                                |                                  |                                |                                  |                   |
|                     |                                |                                  |                                |                                  |                   |
|                     |                                |                                  |                                |                                  |                   |

Bien à vous,  
Yours truly,

Commis à l'administration.  
Administration Clerk.



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

The factory hereby certifies that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

763839

Ship Date

2007-05-01

P.O. No./Govt Contract No.

N19333

B.L. No.

2224008

Invoice No.

00000

Customer

SAMUEL SON & CO LT DCE-39027-1

Ship From: RIVERDALE, IA.

Alcoa No. Item

4539027-1

Mfg Order

Page 1

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3T5 QC

## Item Description

0.08 IN TK (+0 -.0045) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 EXC MRK AMS4027 REV M EXC MRK ASTM209 REV 06 CMMP025 REV Q CMMP019 REV D CSTI008 REV D ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS  
SKID WGT: 4500 LB QUAN TOL +/-30 %  
CQR 0209523 REV 01 CUST REQ 07-04-07 \*\*\* W/E 07-05-12 \*\*\*

| Num | Package Ticket | Lot    | Weight | Quantity | UOM | Pc Id/Serl |
|-----|----------------|--------|--------|----------|-----|------------|
| 1   | 523889         | 655133 | 982    | 20       | PC  | :          |
| 2   | 523891         | 655133 | 512    | 10       | PC  | :          |
| 3   | 524236         | 655133 | 4036   | 79       | PC  | :          |
|     |                |        | 5530   | 109      |     |            |

## Notes for CQR: 0209523.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD UCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.  
Exception to Spec CMMP025 ; Revsn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B.  
Exception to Spec CMMP019 ; Revsn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL.  
Exception to Spec CSTI008 ; Revsn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL.

## CQR: 0209523.1 -Specification Limits

| UTS | TYS  | EL4D    |
|-----|------|---------|
| KSI | KSI  | PCT     |
| Max |      |         |
| Min | 42.0 | 35.0 10 |

## Chemical Composition

| Chemical Composition |     | SI   | FE  | CU   | MN   | MG  | CR   | ZN   | TI   | Other | Other | Aluminum |
|----------------------|-----|------|-----|------|------|-----|------|------|------|-------|-------|----------|
|                      |     |      |     |      |      |     |      |      |      | Each  | Total |          |
| Alloy 6061           | Max | 0.8  | 0.7 | 0.40 | 0.15 | 1.2 | 0.35 | 0.25 | 0.15 | 0.05  | 0.15  |          |
|                      | Min | 0.40 |     | 0.15 |      | 0.8 | 0.04 |      |      |       |       | REMAIN   |

REMAIN



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material described herein was inspected in accordance with the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

763839

Ship Date

2007-05-01

0

B.L. No.

2224008

Invoice No.

00000

Alcoa No. Item

4539027-1

Page 2

P.O. No./Govt Contract No.

N19333

Customer

Mfg Order

SAMUEL SON & CO LT DCE-39027-1

CQR: 0209523.1 -Specification Limits (cont.) -----  
Lot: 655133 - Mechanical, Physical, Metallography, Quantometer Results -----

| Temp | Dir          | No-> | UTS  | TYS  | EL4D |
|------|--------------|------|------|------|------|
|      |              | Test | KSI  | KSI  | PCT  |
| T6   | Long Transv. | 2    | 50.4 | 45.5 | 11.1 |
|      |              |      | 50.2 | 45.4 | 11.2 |

| Cast Number | Chemical | SI   | FE  | CU   | MN   | MG  | CR   | ZN   | TI   |
|-------------|----------|------|-----|------|------|-----|------|------|------|
| H252006E    | Actuals  | 0.65 | 0.4 | 0.25 | 0.06 | 1.0 | 0.19 | 0.08 | 0.02 |

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

